

Date: Friday, 09/05/2008 1:45:41 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER
Job Number :	39163		
Estimate Number :	11169		
P.O. Number :		Part Number :	D32831
This Issue :	09/05/2008	Drawing Number :	D3283 REV E
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	E
Previous Run :	35230	Material :	
Written By :		Due Date :	16/05/2008
Checked & Approved By :	<u>JUL 08.5.09</u>	Qty:	20
Comment :	Est A 04.09.28 New issue KJ/JLM Est Rev:B Now on Waterjet 07-05-28 JLM Est Rev:C As per Rev E 07-09-09 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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7.2



Comment: Qty.: 0.2479 sf(s)/Unit. Total: 4.9581 sf(s)
 6061-T6 .063 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Identify for D3283-1
 Batch: 107387 1B 8-5-13

29

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3283
 Dwg Rev: E
 Prog Rev: E

1B 8-5-13

2-Deburr if necessary 1B 8-5-13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-5-13



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/05/13 429 count

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:45:42 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 39163

Part Number: D32831

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Good 05/13

Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

W/A Done at Set # 2.2

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Good 05/13 (+29)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

W/BK 08-05-13

(29)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/05/13

(29)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST 177

AS 08/05/14

(29)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/15

Job Completion



W 08/05/14

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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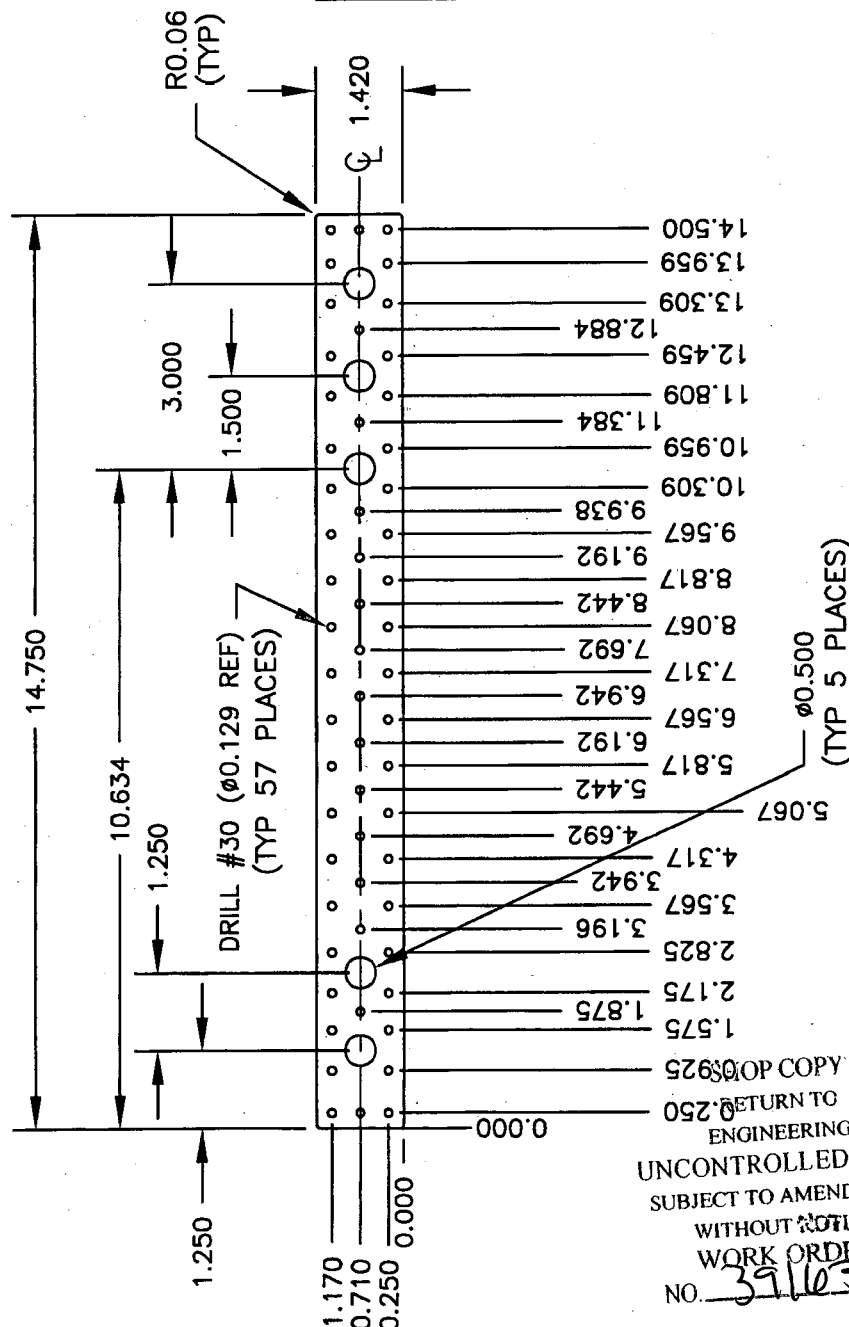
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07-08-2014
PER ECN 959

DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3283	REV. E SHEET 1 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3
A	04.05.06	NEW ISSUE	
B	04.08.09	10.882 WAS 11.502	
C	05.03.16	CHANGE HOLE PATTERN FOR -1	
D	05.08.09	REDESIGN	
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)	



D3283-1 DOUBLER

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

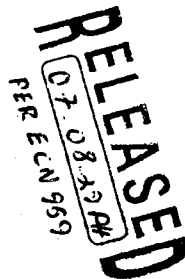
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



15.432

2.750

1.500

0.000

0.250

0.689

1.189

1.689

2.127

0.719

2.377

1.658

C

R0.06 (TYP)

Ø0.188 (TYP 2 PLACES)

Ø0.098 (TYP 85 PLACES)

UNCONTROLLED

SHOP CO. RETURN

ENGINEER

SUBJECT TO AM

WITHOUT N

WORK OF

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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